

Date: Wednesday, 08/10/2008 9:01:45 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 05050
Estimate Number : 10774
P.O. Number :
This Issue : 08/10/2008 **S.O. No.** :
Prsht Rev. : NC
First Issue : / / **Type** : R & D LG FAB
Previous Run : 42501
Written By :
Checked & Approved By :
Comment : Est A 05.09.13 New issue KJ/JLM

Drawing Name : LUG ASSEMBLY
Part Number : D3414041
Drawing Number : D3414 PROTOTYPE
Project Number : N/A
Drawing Revision : A
Material :
Due Date : 14/10/2008 **Qty:** 1 **Um:** Each

Additional Product

FOR ENGINEERING USE ONLY

PROTOTYPE

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

1.0 M304S12GA 304/316 0.100" Sheet



Comment: Qty.: 0.1523 sf(s)/Unit Total: 0.1523 sf(s)
304/316 stainless steel 0.100" Sheet
Batch: 105130 HB 8-10-9

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3414
Dwg Rev: PHOTO
Prog Rev: TYPE

HB 8-10-9

2

2-Deburr if necessary HB 8-10-9

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-10-9

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08/10/16 2

5.0 BRAKE NC NC BRAKE



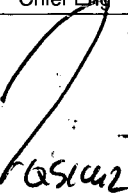
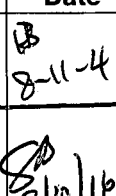
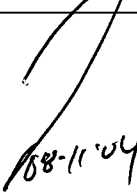
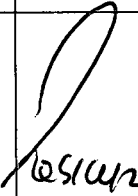
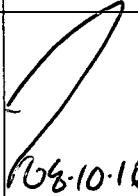
Comment: NC BRAKE
Deburr
Form using DT8254 as per Dwg D3414

HB 08/10/16

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3414-041 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: A Date: 08/12/04
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 05050		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/10/16	2.0	Hole dia ϕ 0.313 is at the min tolerance. on the back side of the hole. 0.310 \rightarrow 0.312 R.C: Tap in the cut.		Modify the program to slightly open to hole more. drill & deburr the holes per dwg.	 8-11-14 8-10-16	 08-11-04	 08/10/16	 08-10-16

NOTE: Date & initial all entries

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Drawing Name: LUG ASSEMBLY

Job Number: 05050

Part Number: D3414041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-11-042

7.0

D34143

Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lug

Pick:

Qty Part Number Description Batch

1 D3414-3 Lug

A/R SS Rod

PTO

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld using location Jig DT8484 as per Dwg D3414

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

Scrap

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



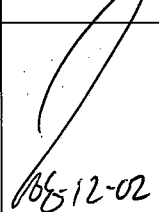
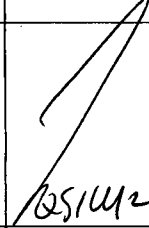
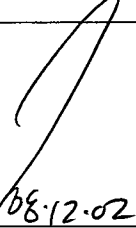


Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-12-02	6.0	2 parts scrap. due to design change/modification on the length to achieve a special height & radius.	 RES/11/12	parts cannot be re-worked to new specs. - scrap & destroy	 08/12/02	 08/12-02	 08/11/12	 08-12-02

NOTE: Date & initial all entries

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Drawing Name: LUG ASSEMBLY

Job Number: 05050

Part Number: D3414041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

**ENGINEERING
APPROVAL**

OK
SCRAP

08.12.02

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-12-02

00569

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

PROTOTYPE

Product #: D205-634, D204-635 & D206-642

Job #: 00569

Date: 08.10.07

Product Name: GHW LUGS

Requested By: AJS

Design Manager Approval: *MWP*

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3405-041	<i>DS048</i>	LUG ASSY	08.09.19	N	08.10.13	FINISHED, CHECK INSTALL PER DSI 9417 REV B	
1	<i>D3405-043</i> D3405-043	<i>DS044</i>	LUG ASSY	08.09.19	N	08.10.13	FINISHED, CHECK INSTALL PER DSI 9417 REV B	
1	D3414-041	<i>DS050</i>	LUG ASSY	08.09.23	N	08.10.13	FINISHED CHECK INSTALL PER DSI 9421 REV B	

DART AEROSPACE LTD	Work Order: 05080
Description: Lube-Ass'y	Part Number: 03414
Inspection Dwg: 03414 , Rev: PROTOTYPE	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x


First Article

x

Prototype

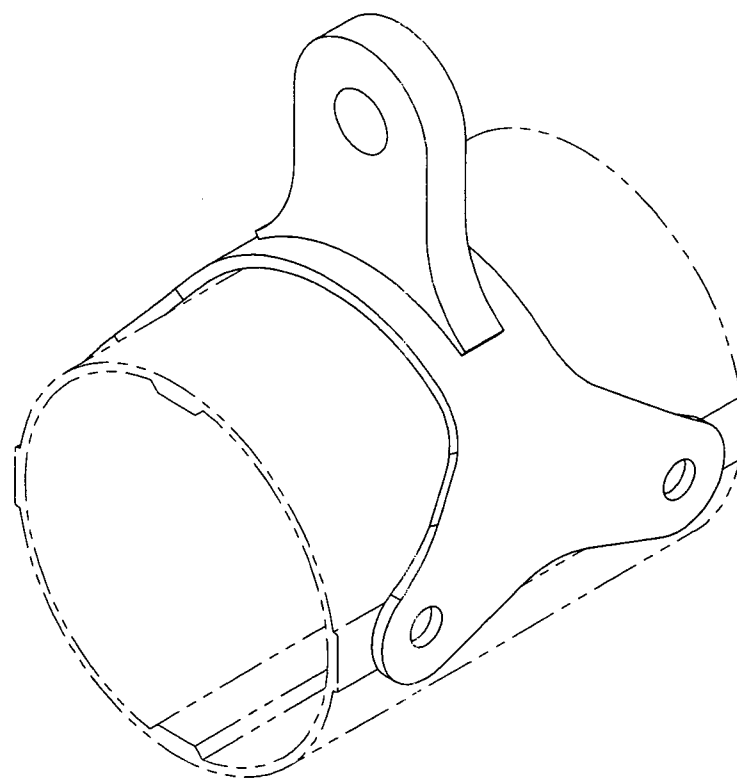
[illegible]

Measured by:	B
Date:	8-10-9

Audited by:	
Date:	25-11-16

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



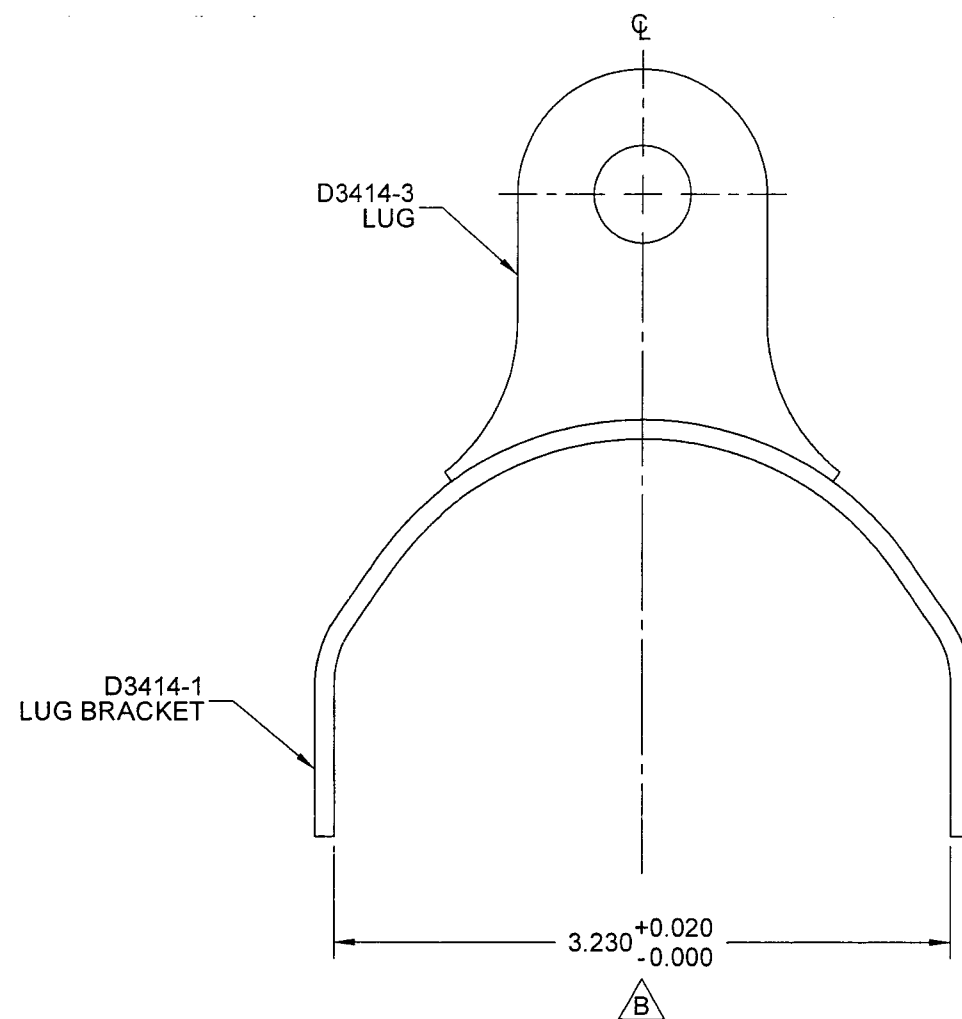
D3414-041 LUG ASSEMBLY

REFERENCE ONLY

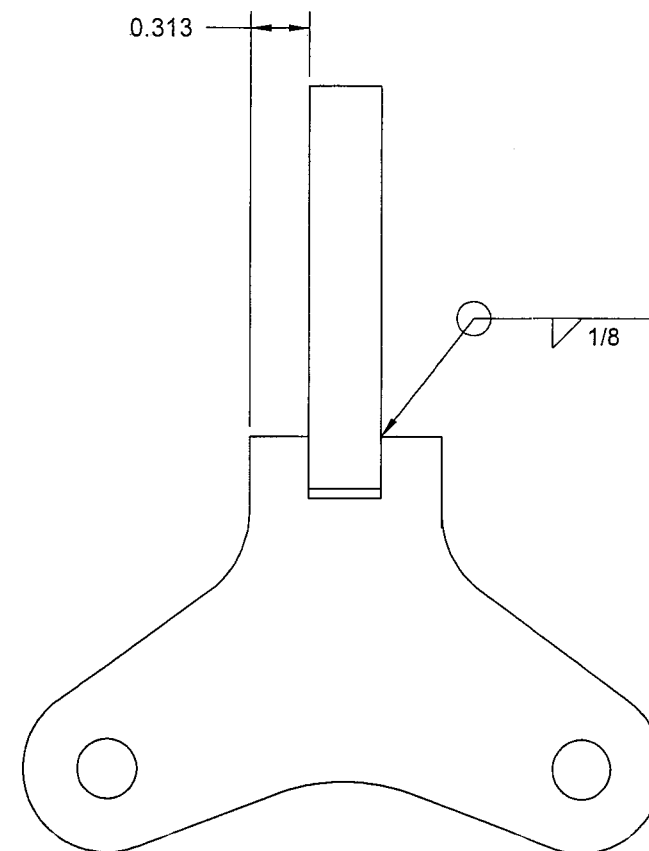
PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
10/10/07

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.52 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEET 3 ZONE B7 ADDED TOLERANCE TO 3.230 DIM, R1.60 DIM WAS R1.575, ZONE C3 R1.70 WAS 1.68, ZONE B3 1.99 DIM WAS 1.92 & 2.06 DIM WAS 1.99.		AJS	08.09.23
A	NEW ISSUE		CP	05.03.16
REV.	DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.		REV. B
MFG. APPR.		D3414		SHEET 1 OF 3
APPROVED		TITLE		SCALE
DE APPR.		LUG ASSEMBLY		NTS
DATE	08.09.23	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		



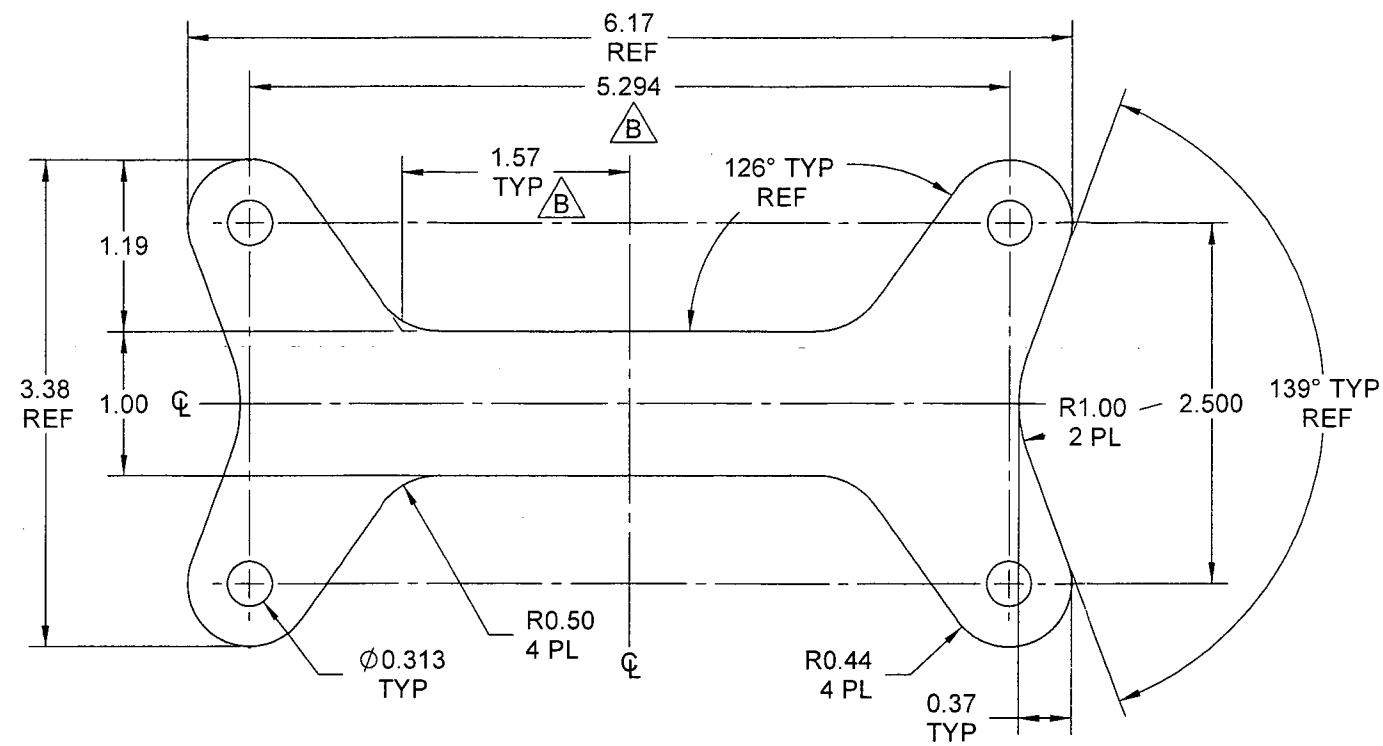
D3414-041 LUG ASSEMBLY



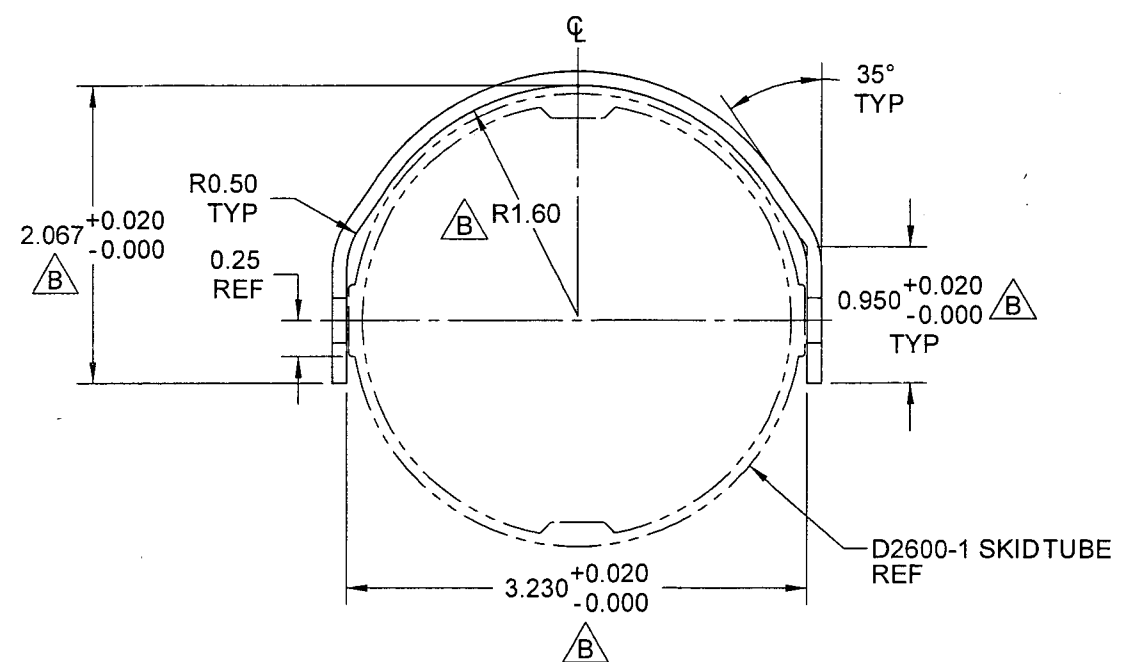
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PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
ASS 08+10.07

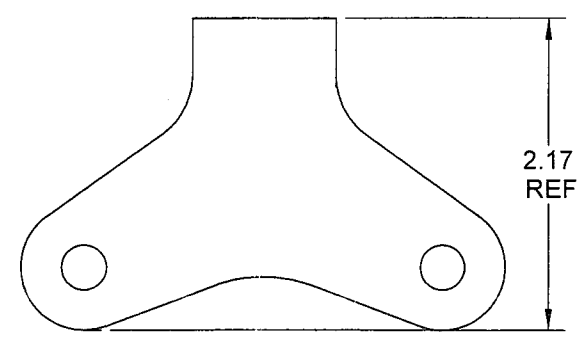
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DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3414	SHEET 2 OF 3
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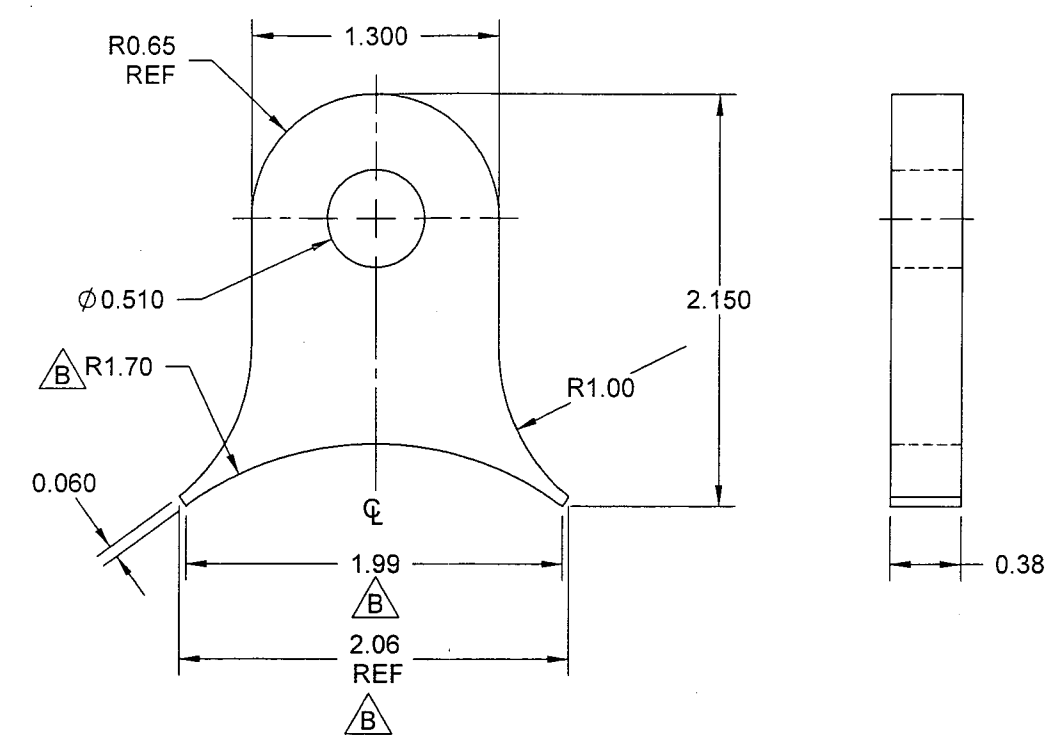
D3414-1F LUG BRACKET



D3414-041 LUG ASSEMBLY



SIDE VIEW FOR REF ONLY



D3414-3 LUG

PROTOTYPE
PLEASE RETURN ALL ISSUED DATA TO ENGINEERING
10/5/06, 10.07

- NOTES:
- 1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA
 - 3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3414	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
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